

Date: Tuesday, 2/26/2008 8:02:56 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : TIRE AND RIM ASSEMBLY
 Job Number : 37649
 Estimate Number : 11156
 P.O. Number :
 This Issue : 2/26/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D32339
 First Issue : / / Type : PURCHASED PARTS Drawing Number : D3233 REV B
 Previous Run : 35436 Drawing Revision : B
 Material :
 Due Date : 3/20/2008 Qty: 12 Um: Each
 Written By :
 Checked & Approved By : 2/26/08 02:26
 Comment : Est. A 05.03.03 New issue KJ/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: 579602/08/02/26

(12)

For D3233-9 Tire and Rim Assembly P/N: 8353T74

Possible Supplier: McMaster-Carr

Product Specification sheet is required

2.0 8353T74 TIRE & RIM



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)
 Tire & Rim Assembly

3.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

08/03/23 (12)

4.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive and Inspect for transit damage

Ensure Product Specification sheet is attached

Identify and Stock

Location: 57446 5747708/3/308/3/4 (12)

5.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/03/04

Job Completion

2008/3/04 (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

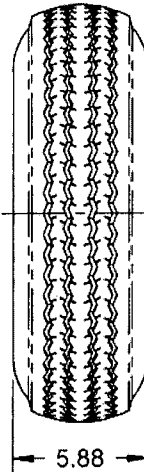
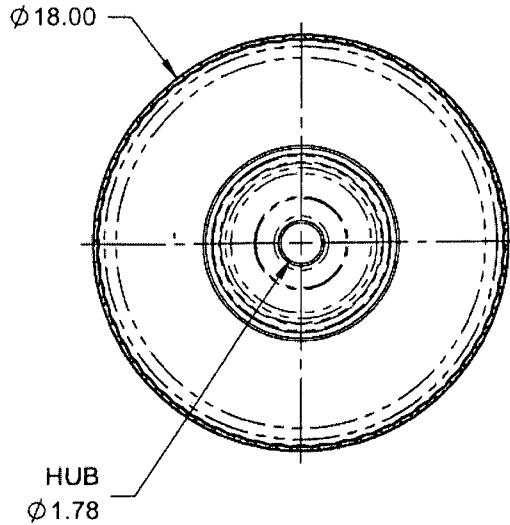
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: FD Date: 08/03/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



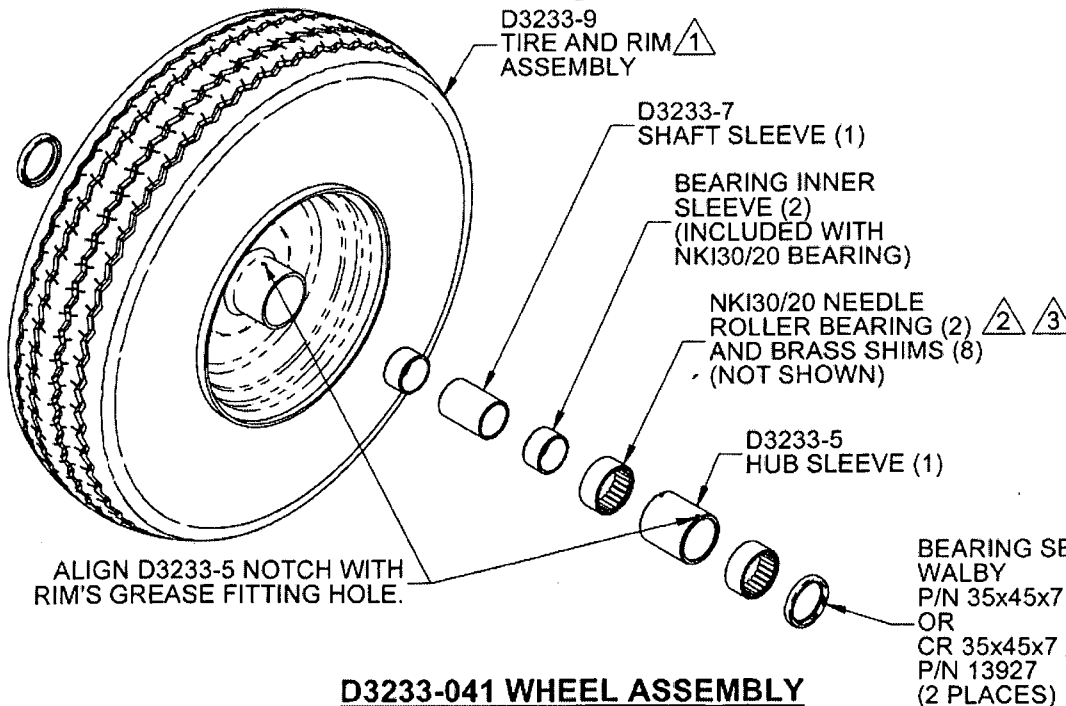
DESIGN 13	DRAWN BY 13	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3233	REV. B SHEET 1 OF 3
DATE 05.03.08		TITLE WHEEL ASSEMBLY	SCALE 1:1
A	05.02.18	NEW ISSUE	
B	05.03.08	ADDED BEARING SEALS	



RELEASED
05/05/04

WHEEL SPECIFICATIONS		
SIZE	MAXIMUM LOAD	MAXIMUM INFLATION LOAD
TIRE: 19.0 x 5.8 RIM: 5.70 x 8.0	910 LBS (RANGE C)	90 PSI*

* MANUFACTURER'S RECOMMENDATIONS
ARE 75 PSI FOR HIGH SPEED USE.



D3233-041 WHEEL ASSEMBLY

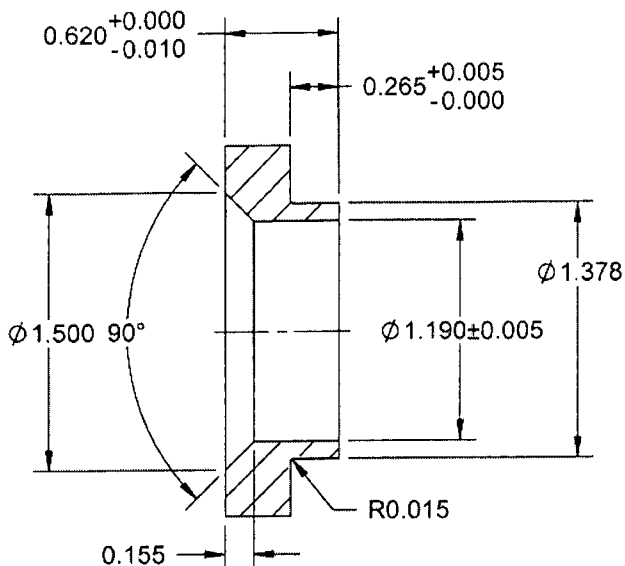
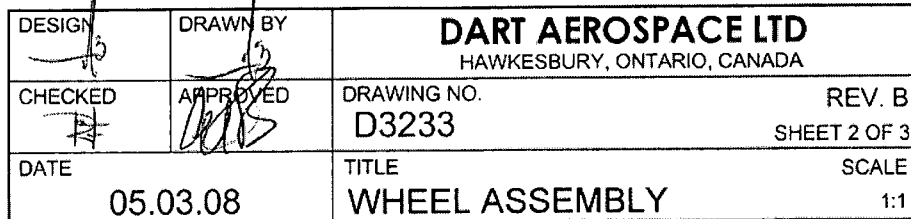
NOTES:

- 1) POSSIBLE SUPPLIER: McMASTER-CARR, P/N 8353T74
- 2) POSSIBLE SUPPLIER: GENERAL BEARING
- 3) PRESS FIT NEEDLE ROLLER BEARINGS INTO RIM HUB WITH
(4) 0.5 X 0.75 X 0.004 BRASS SHIMS PER BEARING, (1) AT EACH QUADRANT.
- 4) POSSIBLE SUPPLIER: GENERAL BEARING
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

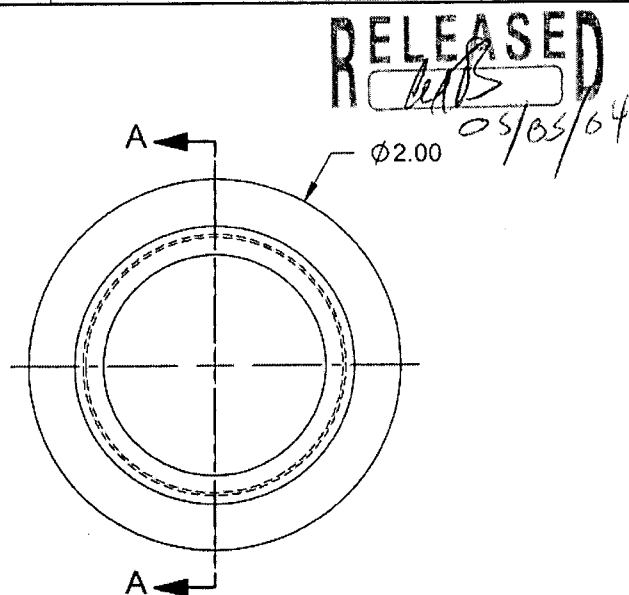
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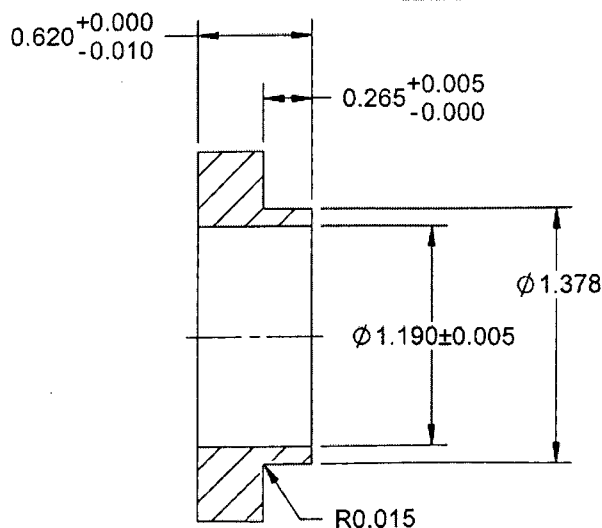
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NO. 37649



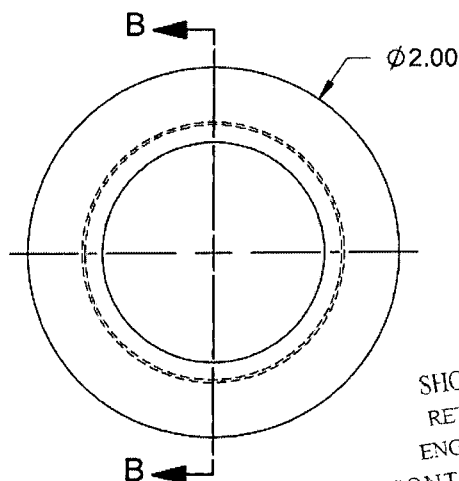
SECTION A-A



D3233-1 INSIDE WASHER



SECTION B-B



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D3233-3 OUTSIDE WASHER

NOTES:

- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513-00
MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESS
(REF. DART SPEC. M1020TR)
- 2) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

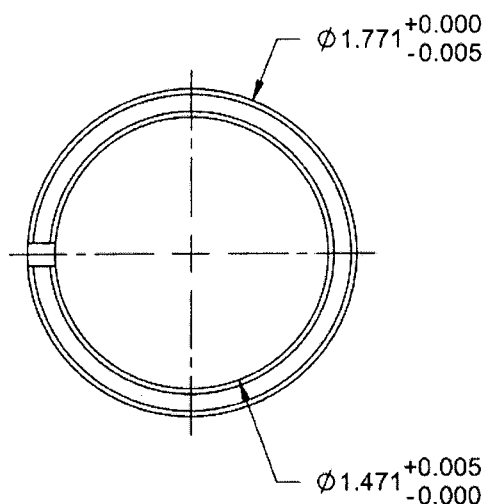
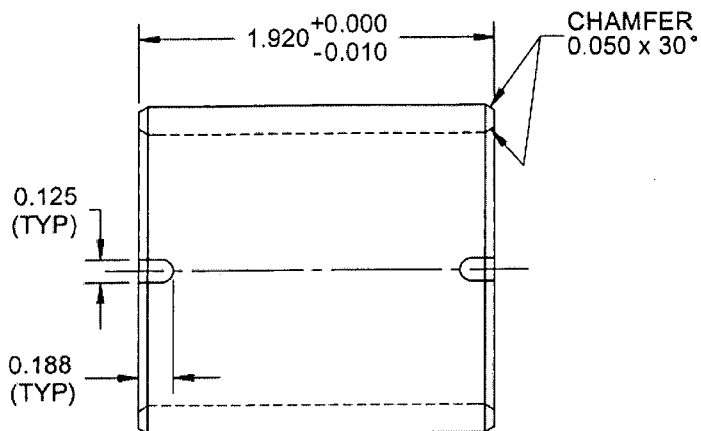
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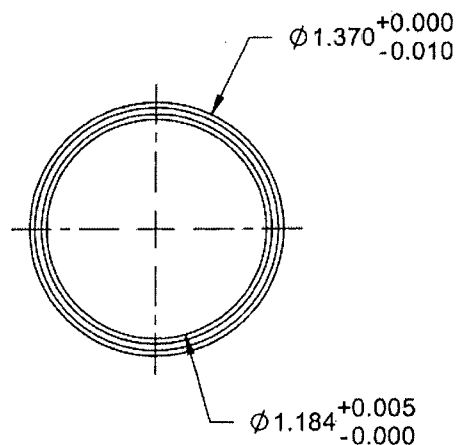
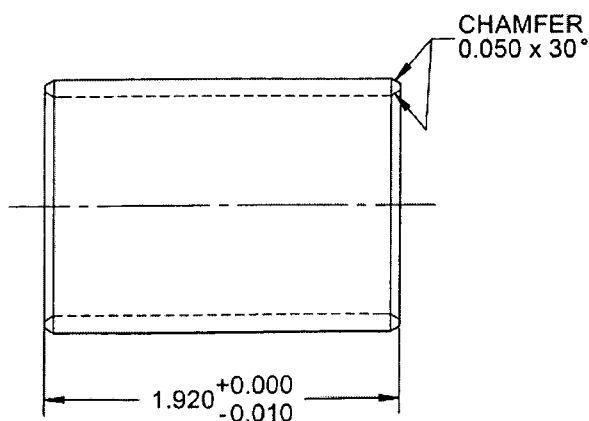


DESIGN 13	DRAWN BY 13	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED R	APPROVED [Signature]	DRAWING NO. D3233	REV. B SHEET 3 OF 3
DATE 05.03.08		TITLE WHEEL ASSEMBLY	SCALE 1:1

RELEASED
[Signature]
05/05/04



D3233-5 HUB SLEEVE



D3233-7 SHAFT SLEEVE

NOTES:

- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513-00 MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESS (REF. DART SPEC. M1020TR)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.030

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McMASTER-CARR®

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Aurora, OH 44202-8087
330-995-5500
cle.sales@mcmaster.com

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K6A 1K7
Canada

Purchase Order
PO00005796

Page 1 of 1

McMaster-Carr Number
6763675-02

02/27/2008

Line	Description	Ordered	Shipped
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5	4146A93 1/2" Hex Shank Arbor for 1-5/16" to 2-9/16", Hole Cutter for Sheet Metal	1 Each	1
1	9504K17 Brass Shim Stock Roll, .004" Thick, 6" Width X 60" Length	3 Each	3
2	2458K14 Carbon-Fiber Race Ball Joint Rod End, 3/8"-24 Right-Hand Male Shank, 4012 Pound Load Capacity	10 Each	10
3	8353T74 Pneumatic Wheel with One-Piece Rim, 18" X 5.9", center Hub, 1-1/4" Axle, Roller Bearing, 1590#cap	12 Each	7

3 - 54 - 13 66 - 25 A93 1 EA

3 - 262

3 - 297

8 - 79

Shipped separately from our Chicago warehouse on 02/27

3	8353T74 Pneumatic Wheel with One-Piece Rim, 18" X 5.9", center Hub, 1-1/4" Axle, Roller Bearing, 1590#cap	12 Each	5
4	4146A38 Hole Cutter for Sheet Metal, 2-1/4" Diameter, Tin Coated	1 Each	1

Dart Aerospace Ltd

Assembly
Area

88

Cycle

30

Shelf

801

Documents

4

EXP



110 lbs
4 lines

FW18SP38
02/27/2008
10:48/11:02
282



8005839689192